



Dart Aerospace Ltd.
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D2281
Job Sheet 201793



DAS
21
9-89

60

Part No: D2281

Job Qty: 60 pcs

Part Name: Jack Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/19

Job Tracking No:

Due Date: 12/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPP: rev B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	50 pcs		12/6/19	0.17	2.62	Waterjet - Flow		JRB 10/27/19
120	QC 8	50 pcs		12/6/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
140	Small Fab - Brake NC - B4B	50 pcs		12/6/19	0.25	1.26	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 -		

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Container No: S226783

Part: D2281

Job No: 201793

Serial No/Batch: S226783

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/27/19

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NOV 3 0 2019

DAS
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10/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				B4B	
				Small Fab - Brake - 3 - B4B	
150	QC 5	50 pcs	12/6/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
160	Packaging 3-1 - Stock - B4B	50 pcs	12/6/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
170	QC 21 - SA	50	12/6/19	0.00 0.00	QC 21 - SA - 21

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12

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pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - 1-Cut as per Dwg Dwg Rev: G Prog Rev: G 2-Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 140 - Form as per D2281 using D2281-T2
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location: W/A001) LOCATION : WA001-1
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	6.2500 sf (.125 ea)	100-Waterjet - Flow - 1	5216339

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S14GA	6	76	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Jack Saddle	4.468Inches ± 0.010	4.478 4.458	4.469	
2	Jack Saddle	4.114Inches ± 0.010	4.124 4.104	4.115	
3	Jack Saddle	2.933Inches ± 0.010	2.943 2.923	2.936	
4	Jack Saddle	1.535Inches ± 0.010	1.545 1.525	1.539	
5	Jack Saddle	0.354Inches ± 0.010	0.364 0.344	0.352	
6	Jack Saddle	0.354Inches ± 0.010	0.364 0.344	0.355	
7	Jack Saddle	0.604Inches ± 0.010	0.614 0.594	0.605	
8	Jack Saddle	2.000Inches ± 0.010	2.010 1.990	2.000	
9	Jack Saddle	3.396Inches ± 0.010	3.406 3.386	3.397	
10	Jack Saddle	3.646Inches ± 0.010	3.656 3.636	3.640	
11	Jack Saddle	4.000Inches ± 0.010	4.010 3.990	4.000 4.005	
12	Jack Saddle	1.525Inches ± 0.010	1.535 1.515	1.529	
13	Jack Saddle	2.475Inches ± 0.010	2.485 2.465	2.476	
14	Jack Saddle	0.323Inches + 0.006 - 0.001	0.329 0.322	Diameter 0.324	
15	Jack Saddle	0.080Inches ± 0.010	0.090 0.070	0.076	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)	
Date: _____	Sequence #: _____	QTY Affected: _____		Disposition			
Description Work Order Deviation				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					